

Date: Thursday, 11/09/2008 10:41:57 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE, OUTBOARD, LH, 206
Job Number : 41974	
Estimate Number : 10818	
P.O. Number :	Part Number : D26651
This Issue : 11/09/2008 S.O. No. :	Drawing Number : D2665 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 41596	Material :
Written By :	Due Date : 10/10/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUL 08.9.11</u>	
Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

7075-T7351 2X6.25X7.875

Cut Size 2.0" x 6.25" x 7.88"

Grain Along Long 7.88 Length

Batch no B34644X931387
B34644X1

JUL 08/09/25

(10)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Program batch number.

1- Inspect part number and batch number are programmed correctly.

2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

5- Deburr

JUL 08/09/25

PTO

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

JUL 08/09/25

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2665-1 PAR #: N/A Fault Category: Prod / Machined Parts NCR: Yes No DQA: D Date: 28/09/30

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>41974</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/09/24</u>	<u>2</u>	<u>1 part scrap run the part at zero PAR 08-024</u>		<u>scrap and destroy replace</u> <u>Qty: 1</u> <u>Batch: 831387</u>	<u>ml</u> <u>08/09/24</u>	<u>CP</u> <u>08-09-24</u> <u>PER BELOW</u>		
<u>08/09/24</u>	<u>2</u>	<u>THICKNESS AT SKID HOLES WAS 0.005" UNDER BEFORE SLOT MACHINED. THERE IS A 0.100" x 0.040" CHAMFER ON TOP EDGE OF SKID HOLE PROFILING</u>	<u>CP</u> <u>08-09-24</u> <u>per</u> <u>08/09/24</u>	<u>0.1235^{+0.005}_{-0.006} THICKNESS WAS MAINTAINED AFTER SLOT WAS MACHINED. CHAMFER ACCEPTABLE. PART OK</u>	<u>ml</u> <u>08/09/24</u>	<u>S</u> <u>08/09/24</u> <u>CP</u> <u>08-09-24</u> <u>per</u> <u>08/09/24</u>	<u>S</u> <u>08/09/24</u>	

NOTE: Date & initial all entries

Date: Thursday, 11/09/2008 10:41:57 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 41974

Part Number: D26651

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 08/09/26

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

08/09/26

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:00
320°F
12:30

M-L

08/09/26

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

8/9/26

SP

(10x)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

u34

8/9/26

SP

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

Job Completion



CY 08/09/29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 41974
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.109	.110	.110	.121		
B	0.100	0.140		.130	.130	.131	.131		
C	1.125	1.145		1.135	1.136	1.134	1.135		
D	0.615	0.685		.657	.660	.666	.660		
E	0.240	0.260		.256	.254	.257	.257		
F	1.313	1.343		1.328	1.328	1.328	1.328		
G	0.210	0.230		.225	.224	.225	.225		
H	0.100	0.180		.133	.135	.133	.133		
I	2.470	2.510		2.491	2.491	2.491	2.491		
J	1.565	1.585		1.574	1.575	1.572	1.574		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.110	.100	.111	.111		
M	0.990	1.010		1.007	1.005	1.000	1.000		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.318	.318	.318	.318		
S	0.315	0.322		.317	.317	.317	.317		
T	2.495	2.505		2.500	2.499	2.500	2.500		
U	1.357	1.367		1.359	1.366	1.363	1.363		
V	0.787	0.807		.795	.794	.794	.794		
W	0.540	0.560		.547	.549	.550	.550		
X	1.674	1.684		1.677	1.679	1.678	1.678		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.924	.924	.925	.925		
AA	0.490	0.510		.500	.500	.500	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>gml</i>
Date: 08/08/24 / 08/09/25

Audited by: <i>J.L.</i>
Date: 08/09/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 41974
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.100	0.140		.130	.110	.113	.113		
B	0.100	0.140		.130	.130	.130	.130		
C	1.125	1.145		1.130	1.130	1.130	1.130		
D	0.615	0.685		.665	.665	.665	.665		
E	0.240	0.260		.250	.250	.254	.254		
F	1.313	1.343		1.328	1.328	1.328	1.328		
G	0.210	0.230		.220	.220	.220	.220		
H	0.100	0.180		.145	.145	.145	.145		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.575	1.575	1.575	1.575		
K	0.235	0.240		.250	.250	.250	.250		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.318	.318	.318	.318		
S	0.315	0.322		.317	.317	.317	.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.360	1.360	1.360	1.360		
V	0.787	0.807		.800	.800	.800	.800		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.680	1.680	1.680	1.680		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.926	.926	.926	.926		
AA	0.490	0.510		.500	.500	.500	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>JS</i>
Date: 08/09/25

Audited by: <i>JS</i>
Date: 08/09/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 41974
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	11	4	By	Date
A	0.100	0.140		.110	.110	.109			
B	0.100	0.140		.130	.130	.128			
C	1.125	1.145		1.135	1.135	1.135			
D	0.615	0.685		.670	.670	.670			
E	0.240	0.260		.250	.250	.250			
F	1.313	1.343		1.320	1.320	1.320			
G	0.210	0.230		.220	.220	.224			
H	0.100	0.180		.140	.140	.140			
I	2.470	2.510		2.490	2.490	2.490			
J	1.565	1.585		1.575	1.575	1.575			
K	0.235	0.240		.238	.238	.239			
L	0.100	0.120		.110	.110	.117			
M	0.990	1.010		1.000	1.000	1.010			
N	0.510	0.515		.510	.510	.510			
O	5.990	6.010		6.000	6.000	6.004			
P	1.245	1.255		1.250	1.250	1.250			
Q	2.495	2.505		2.500	2.500	2.500			
R	0.313	0.318		.317	.317	.317			
S	0.315	0.322		.315	.315	.315			
T	2.495	2.505		2.500	2.500	2.500			
U	1.357	1.367		1.362	1.362	1.362			
V	0.787	0.807		.800	.800	.800			
W	0.540	0.560		.550	.550	.550			
X	1.674	1.684		1.679	1.679	1.679			
Y	0.257	0.262		.258	.258	.258			
Z	0.912	0.932		.918	.918	.918			
AA	0.490	0.510		.500	.500	.500			
AB	0.178	0.198		.188	.188	.188			
AC									
AD									
AE									
AF									
Accept/Reject									

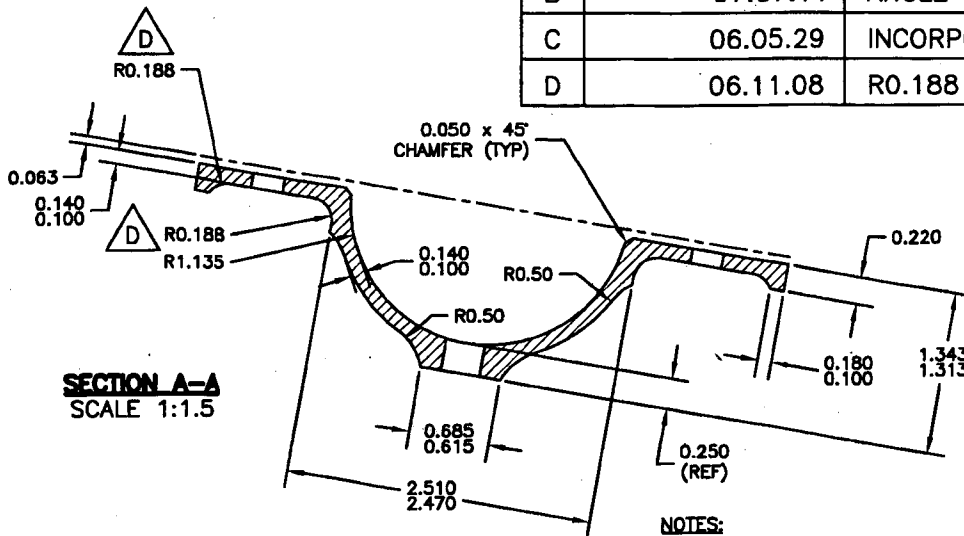
Measured by: <i>S.S.</i>
Date: 08/09/26

Audited by: <i>J.L.</i>
Date: 08/09/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

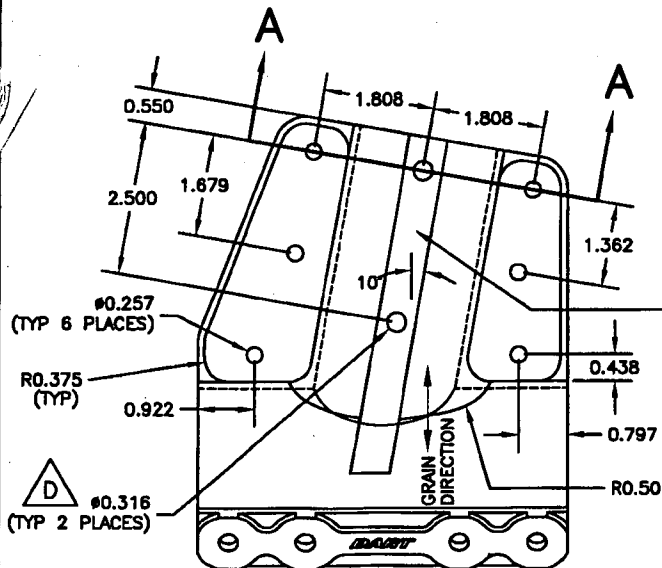


RELEASED

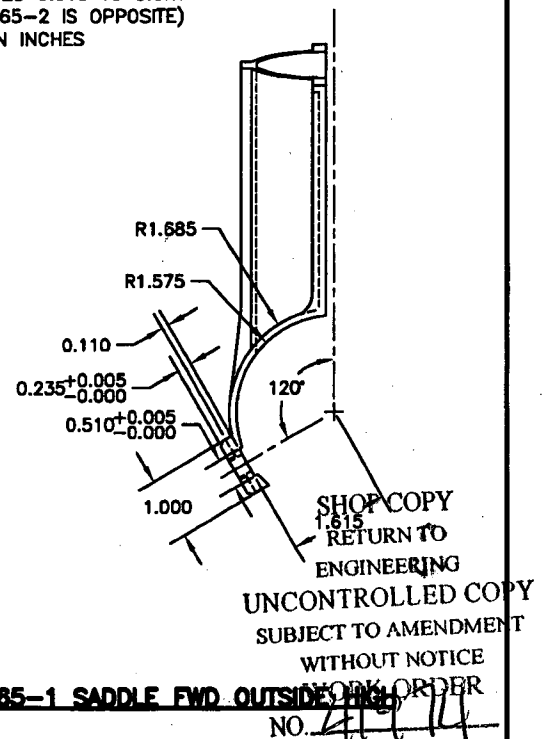
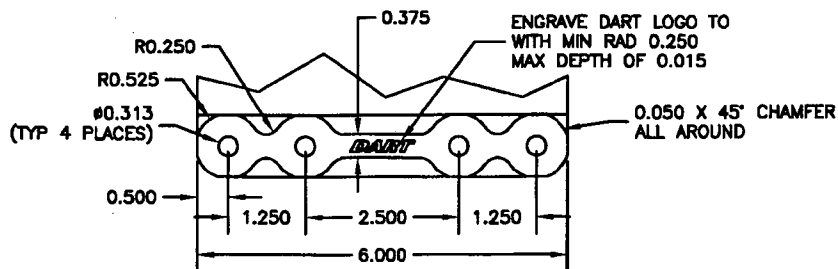
07.02.12

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



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